

Work Order ID 86043

June-19-12 4:09:50 PM

86043

Page 1

Item ID: D3852-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib/Assembly

Start Date: 19/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/20* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3852	Rev. A
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100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: *ML21602*

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

(2) Q OK 12/06/27

CC 12-6-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Rib Assembly

Start Date: 19/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00

130

QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

12.07.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Item Name: Rib Assembly

Start Date: 19/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/7/4 *[Signature]*
#1207-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

June-19-12 4:09:58 PM

Page 1

Work Order ID: 86043

86043

Parent Item: D3852-042

D3852-042

Parent Item Name: Rib Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3166-3		Manufactured	No			100	Each	1.4420	0.18	0.378947			
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D3166-3

Basket Hoop

**

DL 12/06/27
12/06/27

Location	Loc Qty	Loc Code
WA	0.8632	
81578	0.8632	
WA007	0.5788	
77294	0.5788	

0.3780

D3759-1		Manufactured	No			100	Each	218.0000	1	2			
---------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

D3759-1

Bushing

**

CC 12-6-28

Location	Loc Qty	Loc Code
WA	163	
79213	1	
83464	162	
WA005	55	
66489	1	
82785	54	

2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB

D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86073 MCT

12/06/20

RELEASED
08/11/18 MCT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs EACH
- 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
SHEET 1 OF 3
TITLE **RIB ASSEMBLY** SCALE NTS

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

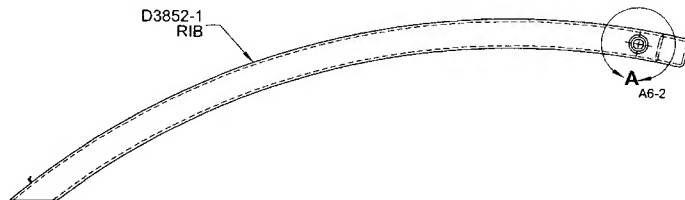
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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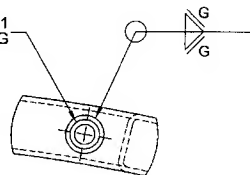


D3852-1
RIB



D3852-041 RIB ASSEMBLY

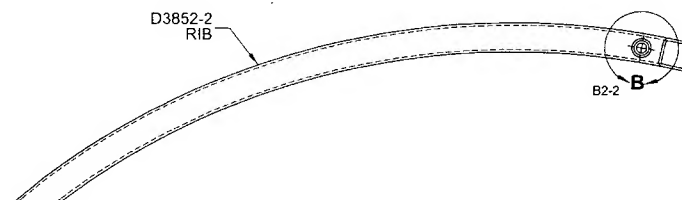
D3759-1
BUSHING



DETAIL A
SCALE 2X C5-2

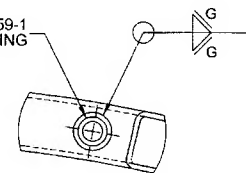


D3852-2
RIB



D3852-042 RIB ASSEMBLY

D3759-1
BUSHING



DETAIL B
SCALE 2X C2-2

86643

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	125	DRAWING NO. D3852	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
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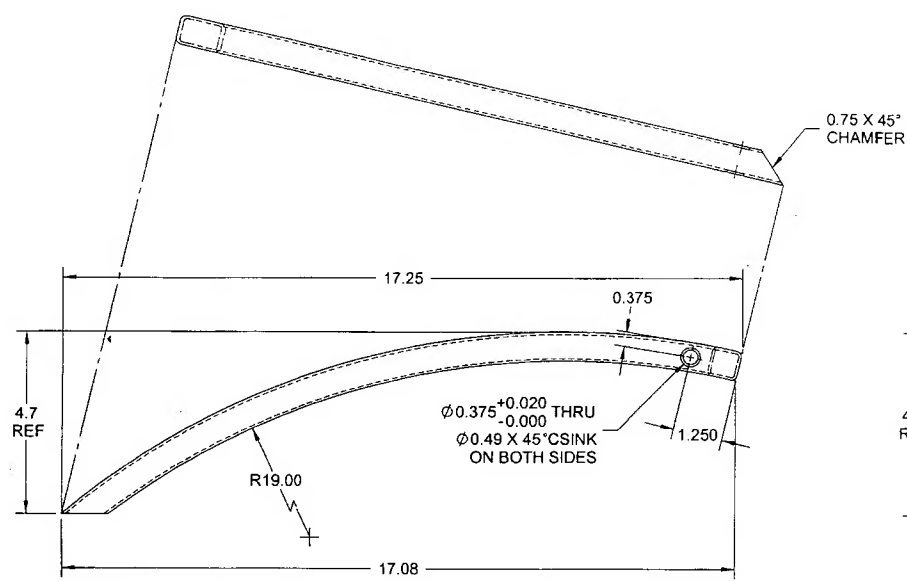
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

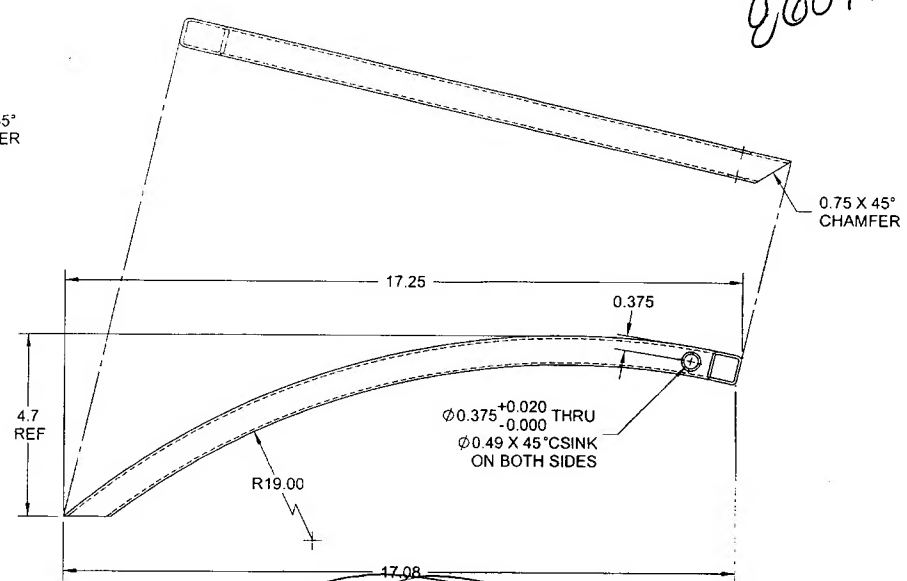
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NOTE: Date & initial all entries

06043



D3852-1 RIB



D3852-2 RIB

RELEASED
08/11/07

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.82 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASB</i>	DRAWING NO. D3852	REV. A
MFG. APPR.		SHEET 3 OF 3	
APPROVED	<i>JS</i>	TITLE RIB ASSEMBLY	SCALE
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